

# Work Order ID 64026

Tuesday, November 23, 2010 8:06:08 AM



Page 1

Item ID:	D3913-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Long Basket Base Assembly, 350					
Start Date:	11/23/2010	Start Qty:	1.00			
Required Date:	11/30/2010	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:		Date:	10-11-23	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3913	A								
100	Weld per dwg A/R S.S. rod Batch: 11585	0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2- tack weld mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket***								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
	QC								
Quality Control	Memo	0.00							

*Pl 10.12.16*

*10.12.17*

*1*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 64026**

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Item ID: D3913-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Base Assembly, 350

Start Date: 11/23/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

0.00

Memo

8.12/20

(76)

125



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

0.00

Memo

1 BR 10-12-20

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

Assemble as per dwg

0.00



HandFinish

Memo

0.00

Hand Finishing

Pick Kit

EF 10/12/20 @

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 01/12/10

~~EF 10/12/20 @~~

170

Identify as per dwg & Stock Location: *G-A*

0.00



Packaging

Memo

0.00

Packaging

*w/o  
64024*

EF 10/12/20 @

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/12/2010  
MF  
10-12-20

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Tuesday, November 23, 2010 8:06:12 AM

Page 1

Work Order ID: 64026

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350




Start Date: 11/23/2010


Required Date: 11/30/2010

Start Qty: 1.00


Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC  
chg qty's DD 10.04.12 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2581  Mounting Bracket		Manufactured	No			100	Each	31.0000	2	2			
<div> <div> <u>Location</u> WA 61953 63493 </div> <div> <u>Loc Qty</u> 31 20 11 </div> <div> <u>Loc Code</u>  </div> </div>													
D3913-1  Rib		Manufactured	No			100	Each	6.0000	1	1			
<div> <div> <u>Location</u> WA 60674 60731 63752 </div> <div> <u>Loc Qty</u> 6 2 3 1 </div> <div> <u>Loc Code</u>  </div> </div>													
D3913-15  Wide Handle Plate		Manufactured	No			100	Each	4.0000	1	1			
<div> <div> <u>Location</u> WA 60732 </div> <div> <u>Loc Qty</u> 4 4 </div> <div> <u>Loc Code</u>  </div> </div>													


 Cpl 10.12.16

(2)

 Cpl 10.12.16

~~860732~~ → (1)

(1)

 Cpl 10.12.16

(1)

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Parent Item Name: Long Basket Base Assembly, 350

Start Date: 11/23/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

D3913-3  
Rib

Manufactured No

100 Each

4.0000

1

Location

Loc Qty

Loc Code

WA

4

60675

3

63753

1

D3913-7  
Rib

Manufactured No

100 Each

6.0000

2

Location

Loc Qty

Loc Code

WA

6

60263

6

D3913-9  
Hinge Rib

Manufactured No

100 Each

4.0000

1

Location

Loc Qty

Loc Code

WA

4

60704

3

63754

1

D3916-041  
Rib Assembly

Manufactured No

100 Each

0.0000

2

D3916-5  
Light Rib

Manufactured No

100 Each

8.0000

3

Location

Loc Qty

Loc Code

WA

8

57023

2

60721

6

*Cpl 10.12.16*

*①*

*Cpl 10.12.16*

*②*

*Cpl 10.12.16*

*①*

*B63624 → ② Cpl 10.12.16*

*B63856 → ② Cpl 10.12.16*

*B60721 → ①*

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Shop Packet Print

Page 2

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Work Order ID: 64026

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 11/23/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

D4016-1  
Hinge Half, Base

Manufactured No

100 Each 3.0000

3

Location

Loc Qty

Loc Code

ST109

3

61062

3

Cpl 10.12.16

B63626 → ③

D4017-7  
Rib

Manufactured No

100 Each 5.0000

1

Location

Loc Qty

Loc Code

WA

5

58929

2

61063

2

63757

1

Cpl 10.12.16

①

D4017-9  
Rib

Manufactured No

100 Each 2.0000

2

Location

Loc Qty

Loc Code

WA

2

60262

2

Cpl 10.12.16

B63622 → ②

D4020-1  
Mesh (350 Basket Long, Base)

Manufactured No

100 Each 2.0000

1

Location

Loc Qty

Loc Code

WA

2

60583

2

Cpl 10.12.16

B63666 → ①

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Page 3

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Tuesday, November 23, 2010 8:06:13 AM

Page 4

Work Order ID: 64026



Parent Item: D3913-041



Parent Item Name: Long Basket Base Assembly, 350

Start Date: 11/23/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

D4020-11 Manufactured No

100 Each

7.0000

2



End Mesh, Basket



*Pl 10.12.10*

Location

Loc Qty

Loc Code

WA

7

59413

1

61306

6

D4021-1 Manufactured No

100 Each

6.0000

3



Handle Plate



*Pl 10.12.14*

Location

Loc Qty

Loc Code

ST109

5

57086

5

WA

1

60677

1

D4034-041 Manufactured No

100 Each

1.0000

1



Aft Upper Rib Assembly



*B63625 -> 3*

Location

Loc Qty

Loc Code

WA

1

61064

1

D4034-043 Manufactured No

100 Each

2.0000

1



Fwd Upper Rib Assembly



*B63621 -> 1*

Location

Loc Qty

Loc Code

WA

2

61065

2

*1*

Tuesday, November 23, 2010 8:06:13 AM

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Page 4

W/O:		WORK ORDER CHANGES					
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Tuesday, November 23, 2010 8:06:13 AM

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Work Order ID: 64026

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 050

Start Date: 11/23/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

AN3-10A Purchased No

150

Each

79.0000

6



Bolt

Location

Loc Qty

Loc Code

ST351

79

115877

35

116075

44

6  
EBS 10/12/20

AN960JD8 NAS1149DN832 Purchased No

150

Each

10.0000

2



Washer

47M116391 (2x)

Location

Loc Qty

Loc Code

ST347

10

105059

10

6  
EBS 10/12/20

D2931 Manufactured No

150

Each

766.0000

2



Bumper

Location

Loc Qty

Loc Code

ST504

766

46064

766

2  
EBS 10/12/20

D4021-5 Manufactured No

150

Each

3.0000

2



Blanking Plate

Location

Loc Qty

Loc Code

ST111

3

60717

3

2  
EBS 10/12/20  
364243

Tuesday, November 23, 2010 8:06:13 AM

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Page 5

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Tuesday, November 23, 2010 8:06:13 AM

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Work Order ID: 64026

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, .50

Start Date: 11/23/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

MS20600-AD4W3 Purchased No

150 Each

1,483.000 2



Cherry Rivets

Location

Loc Qty

Loc Code

ST321

1483

107939

754

111636

729

MS21042L3 Purchased No

150 Each

1,627.000 6



Nut

Location

Loc Qty

Loc Code

ST300

1627

114784

631

115835

996

NAS1149F0332P Purchased No

150 Each

463.0000 12



WASHER

Location

Loc Qty

Loc Code

ST275

463

18057

463

2  
E 11/23/2010

6  
E 11/23/2010

12  
E 11/23/2010

12

Tuesday, November 23, 2010 8:06:13 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

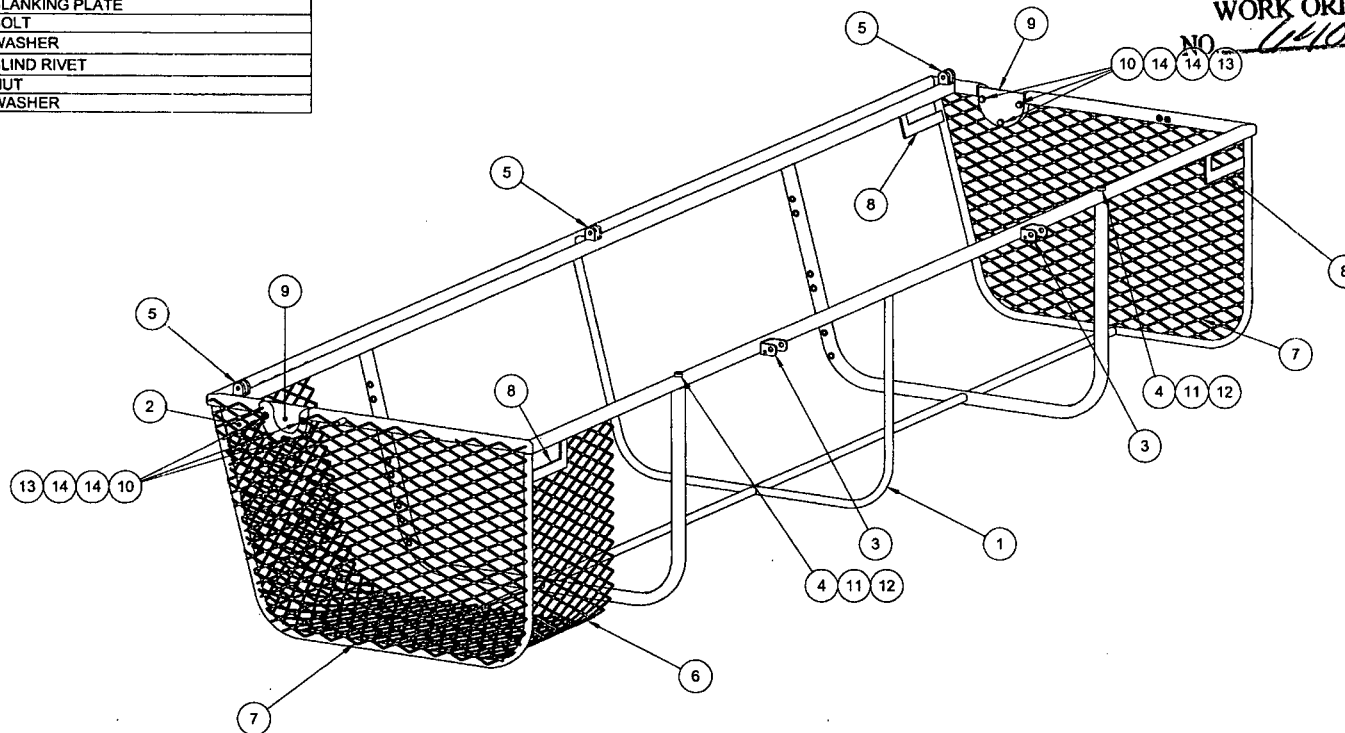
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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ITEM	QTY	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



**D3913-041 LONG BASKET BASE ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 641024  
P/10-11-23

**RELEASED**  
2010-03-22  
JPH

A NEW ISSUE		JPH	10.03.16
REV.	DESCRIPTION		BY DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3913</b> REV. A SHEET 1 OF 6 TITLE <b>LONG BASKET BASE ASSY (350) NTS</b> SCALE COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	JPH		
CHECKED	JPH		
MFG. APPR.	JPH		
APPROVED	JPH		
DE APPR.	JPH	DATE <b>10.03.16</b>	

W/O:		WORK ORDER CHANGES					
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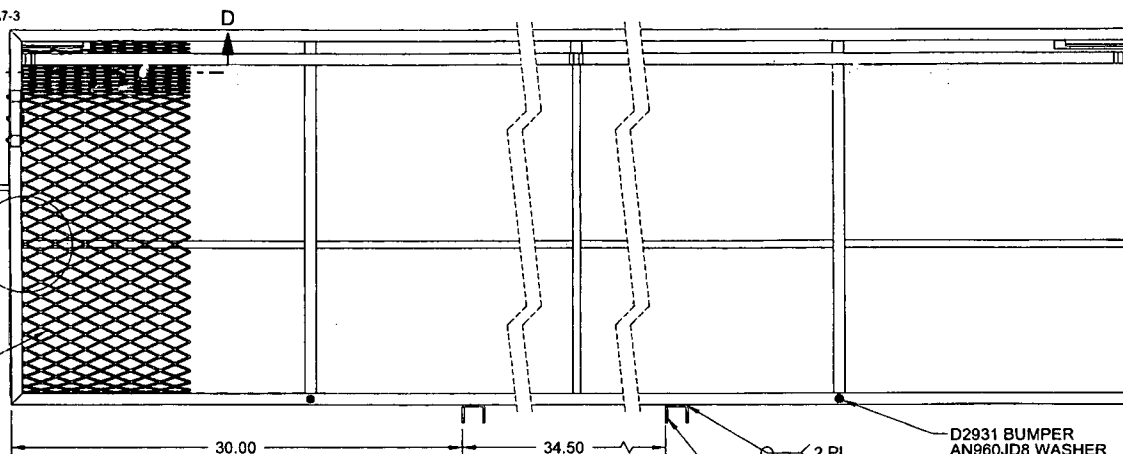
**NOTE:** Date & initial all entries



TACK WELD MESH  
AT EVERY AVAILABLE  
LOCATION

**DETAIL C** D7-2

D A7-3  
D  
D8-2  
D4020-1  
MESH



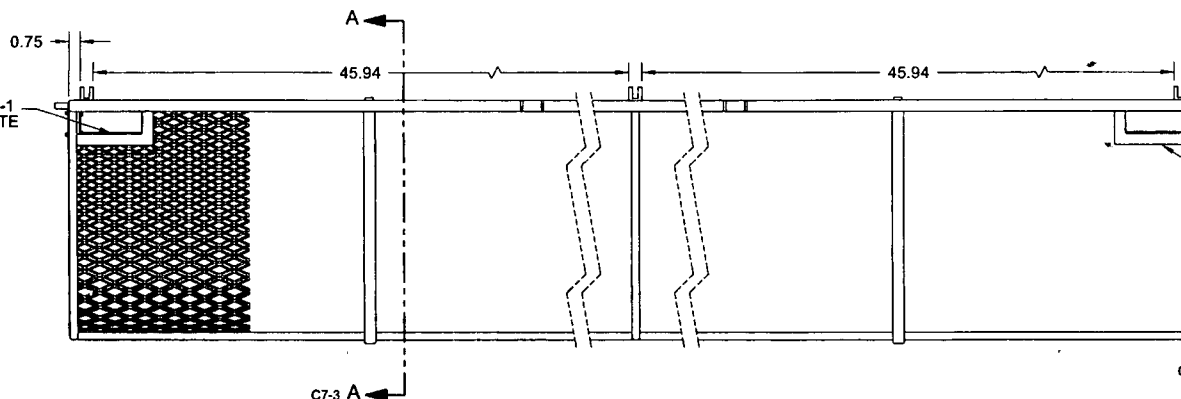
D3913-101  
TUBULAR ASSY

*W064024*

D2931 BUMPER  
AN960JD8 WASHER  
MS20600AD4W3 RIVET  
2 PL (8)

D2581  
MOUNTING BRACKET  
2 PL

0.75  
D4021-1  
HANDLE PLATE



D4016-1  
HINGE HALF, BASE  
3 PL

D4021-1  
HANDLE PLATE  
2 PL

**D3913-041 LONG BASKET BASE ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**RELEASED**  
2010-02-22

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JRH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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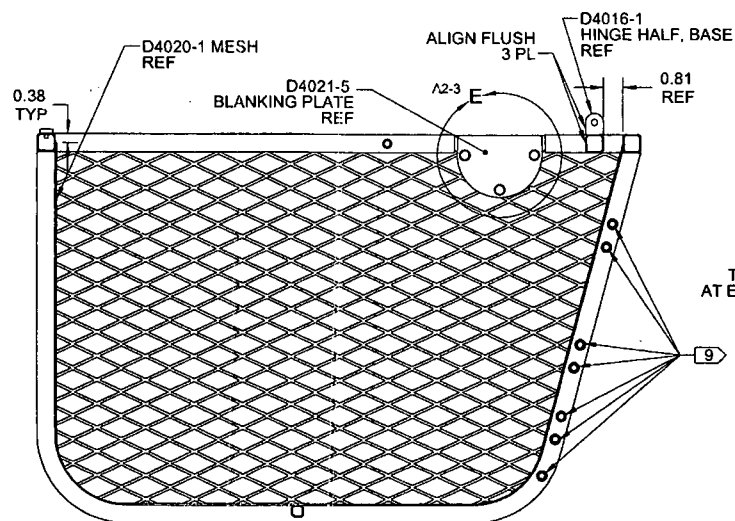
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

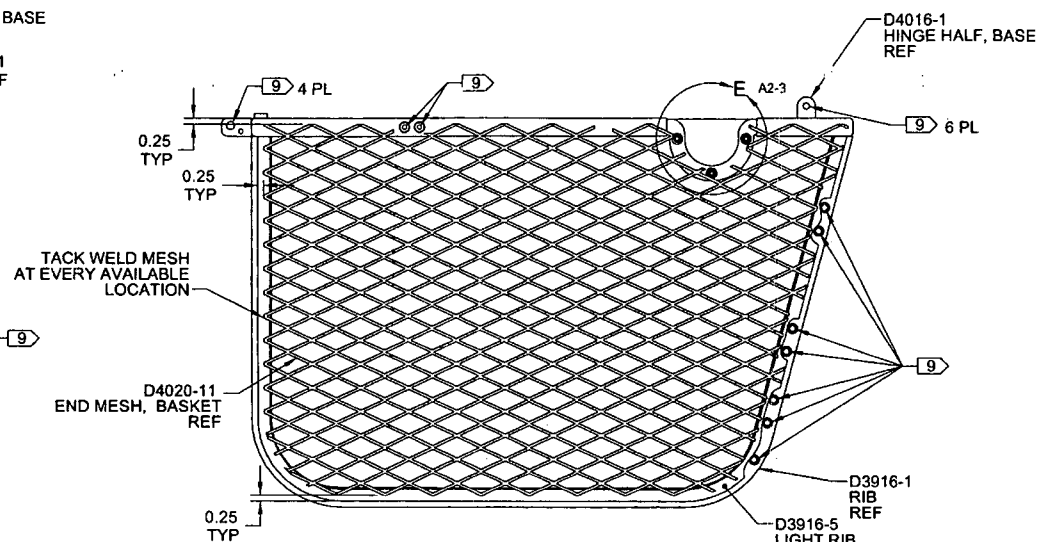
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

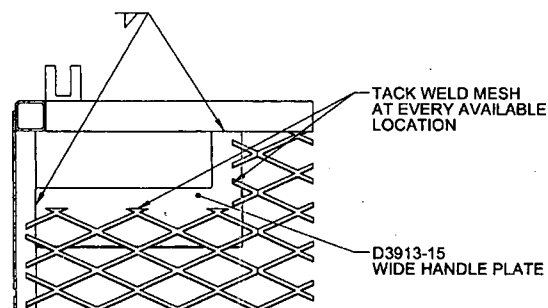
**NOTE:** Date & initial all entries



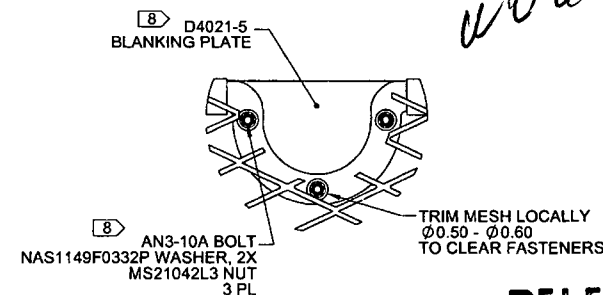
**SECTION A-A** A5-2



**VIEW B-B** A2-2



**SECTION D-D** D7-2  
TYPICAL FOR ALL  
HANDLE PLATES



**DETAIL** D2-3  
D6-3

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<del>_____</del>	DRAWING NO.	REV. A
MFG. APPR.	<del>_____</del>	D3913	SHEET 3 OF 6
APPROVED	<del>_____</del>	TITLE	SCALE
DE APPR.	<del>_____</del>	LONG BASKET BASE ASSY (350) NTS	
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*1064026*

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2010-03-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

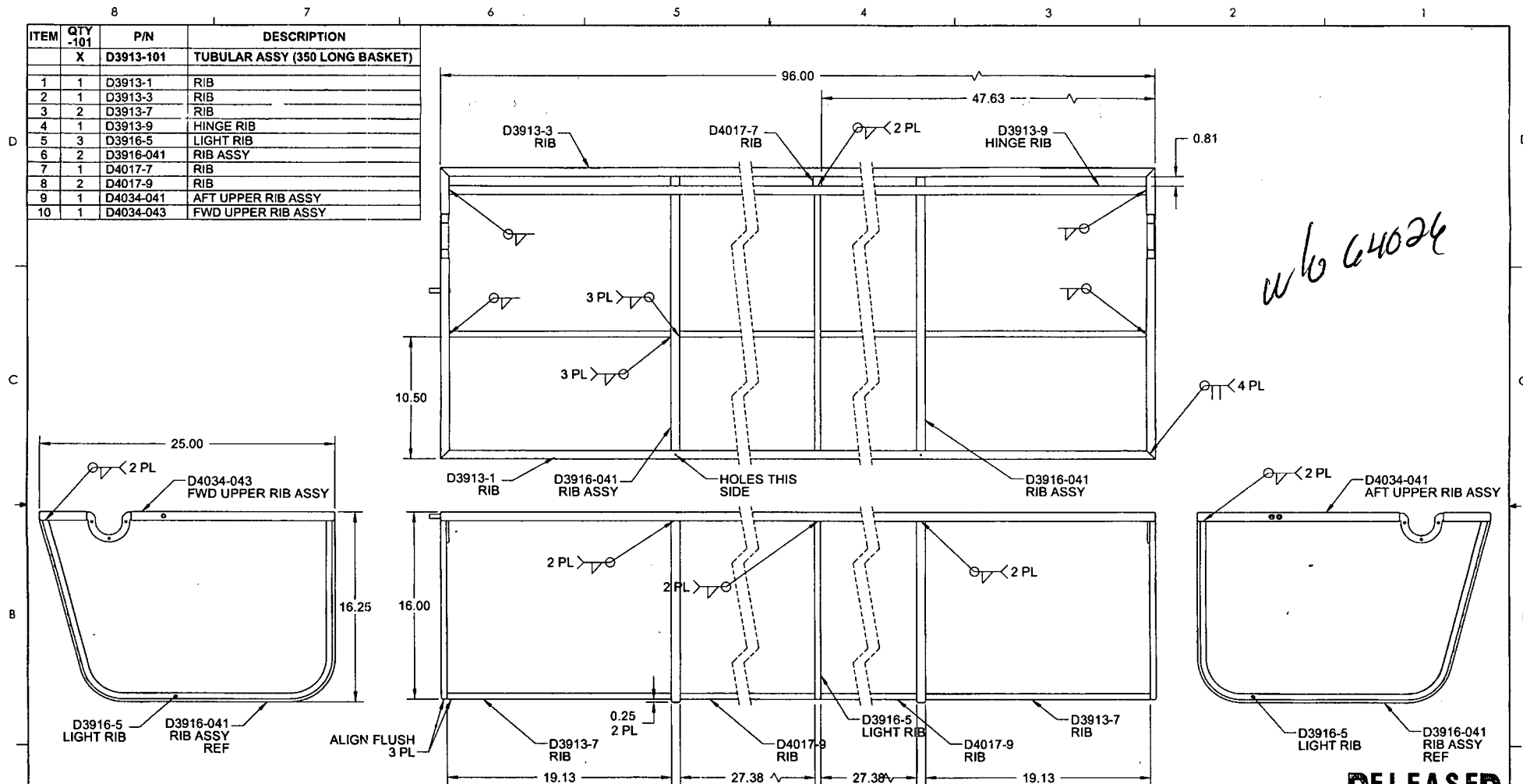
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.53 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D3913-101
- 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JRH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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2010-03-22

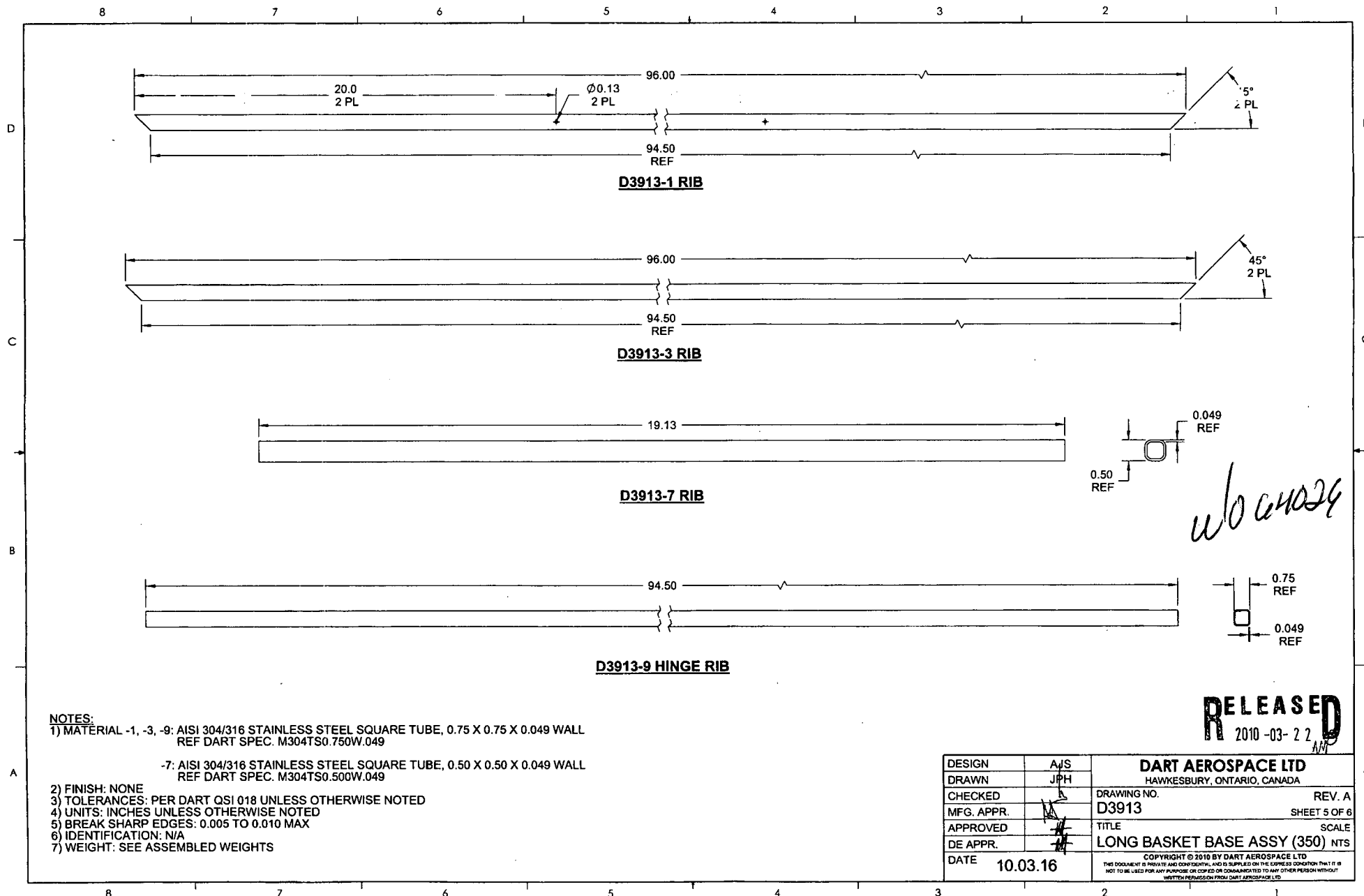
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

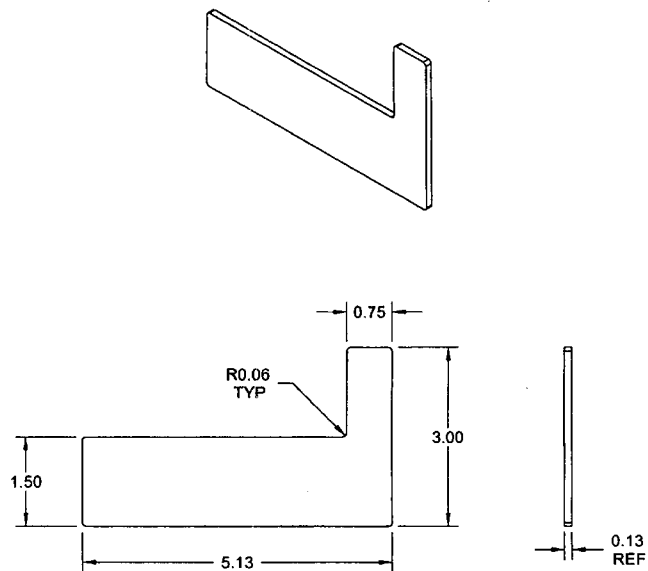
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**D3913-15 WIDE HANDLE PLATE**

**NOTES:**

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JRH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 6 OF 6
APPROVED		TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries